

Date: Wednesday, 2/20/2008 4:24:49 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	CABLE GUARD		
Job Number	37554		Part Number	D29163		
Estimate Number	12457		Drawing Number	D2916 REV B		
P.O. Number	:		Project Number	N/A		
This Issue	2/20/2008	S.O. No. :	Drawing Revision	B		
Prsht Rev.	NC		Material	:		
First Issue	1 /	Type : SMALL /MED FAB	Due Date	3/5/2008	Qty:	4
Previous Run	27905		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	:					
Est Rev:A New Issue 06-06-19 JLM Est Rev:B Now water jet 06-07-14 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MUHMWB10	UHMW 1" Black	
Comment: Qty.: 0.5775 sf(s)/Unit Total : 2.3100 sf(s) UHMW 1" Black batch: <u>107067</u> <u>IR 8-2-25</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D2916 Dwg Rev: <u>B</u> <u>IR 8-2-25</u> Prog Rev: <u>B</u> (4)			
2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IR 8-2-25</u>			
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 BATCH: <u>107067</u> 1- Mill as per Folio FA2916-3 Rev: <u>A</u> & Dwg D2916 Rev: <u>B</u> J.L 08/08/05			
2-Deburr per dwg D2916			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2916-3 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: 12 Date: 08/03/12
 QA: N/C Closed: 12 Date: 08/03/12

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/05	4.0	- 2 parts are scrapped Both part one and two lifted while machining and counter bore went thru R.C. poor tooling	<u>asuruz</u>	- scrap + destroy and Resolve B2 in lot 067 08/03/05	J.L 08/03/05	<u>08/03/11</u>	<u>asuruz</u>	<u>08/03/05</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 37554

Part Number: D29163

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L / 11/14 08/03/08

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/03/11 (4)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

L.S/3/50 (4)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

R.D 08/03/12

Job Completion



~ 2008/3/11

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37554
Description: Cable Guard	Part Number:	D2916-3
Inspection Dwg: D2916 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

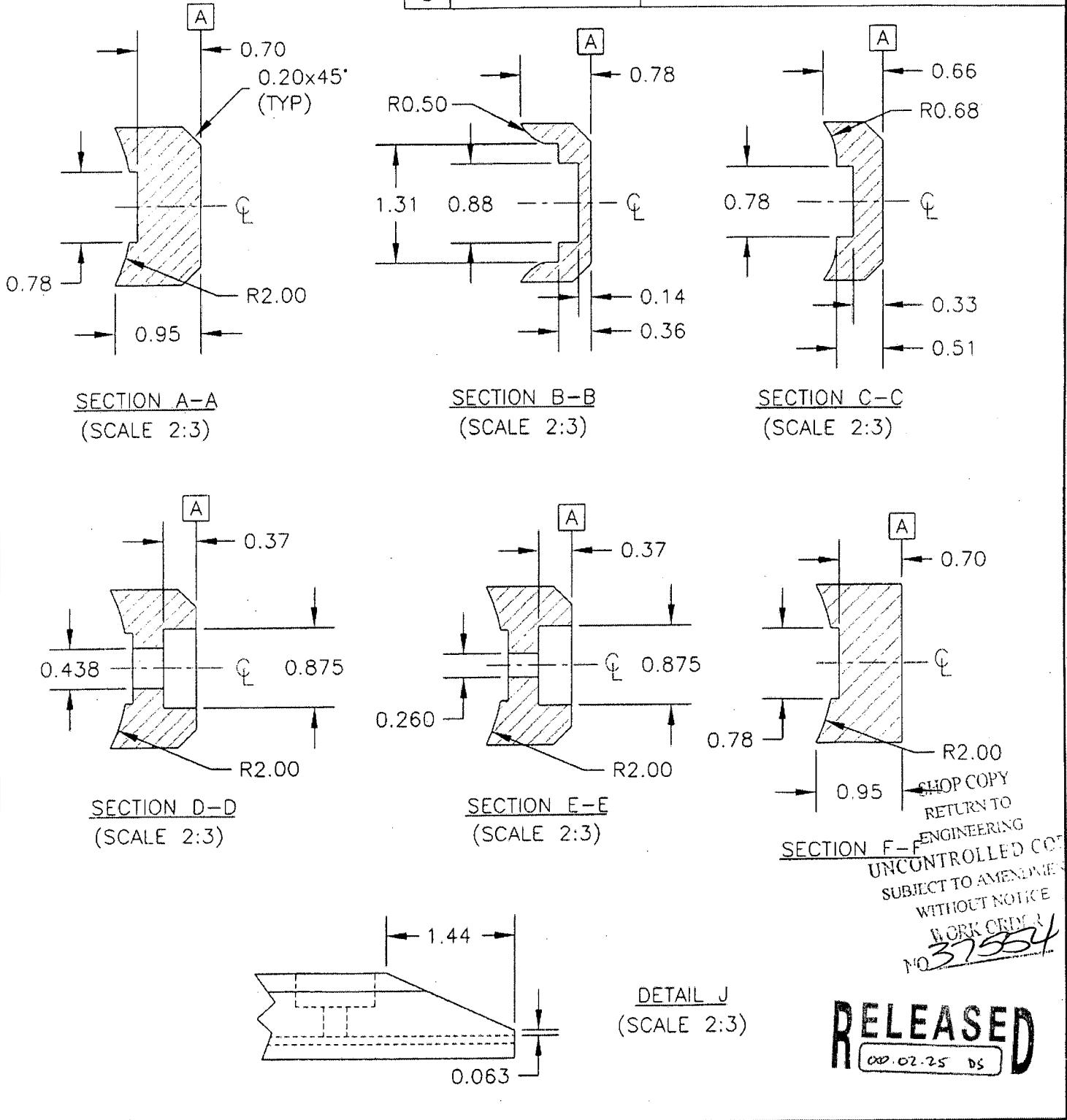
Measured by: B / J.L	Audited by: J.L	Prototype Approval: N/A
Date: 8-3-25 / 08/03/11	Date: 08/03/11	Date: N/A

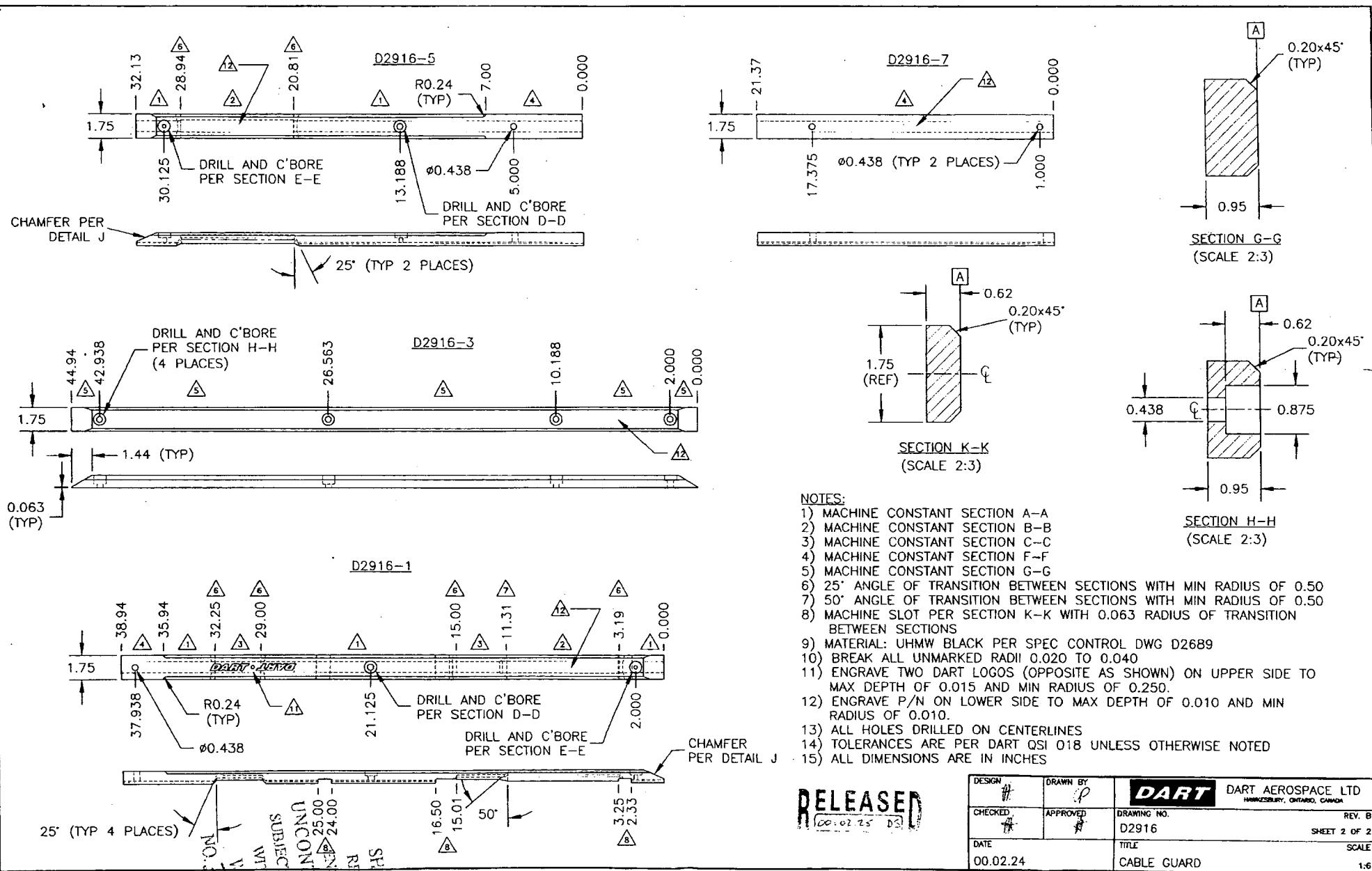
Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	P/O D205-665-015	KJ/RF <i>[Signature]</i> <i>[Signature]</i>

DART

OF COPY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2916
		REV. B SHEET 1 OF 2
DATE		TITLE CABLE GUARD
00.02.24		SCALE 1:6
A	99.09.29	NEW ISSUE
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY





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WORK ORDER
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RELEASED
00.02.25 DS

DESIGN #	DRAWN BY	DART	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2916	
DATE		REV. B SHEET 2 OF 2 TITLE CABLE GUARD SCALE 1:6	